

Date: Friday, 26/09/2008 10:53:38 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKIDTUBE ASSEMBLY
Job Number :	42291A		
Estimate Number :	12548		
P.O. Number :		Part Number :	D206642545
This Issue :	26/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3274 REV D
First Issue :	1/1	Project Number :	N/A
Previous Run :	42276A	Drawing Revision :	D
	Type :	Material :	
	SKIDTUBES	Due Date :	10/10/2008
Written By :		Qty:	1
Checked & Approved By :	JUL 08-9-26	Um:	Each
Comment :	Est Rev:A New Issue 06-10-06 JLM Est Rev:B Added SS Wearplates & Gaskets 07-02-23 JLM Est Rev:C ECN 1080p 07-12-06 DD verified by: Est Rev:D as per PAR 08-015 08-04-17 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	DC	DOCUMENT CONTROL								
Comment: DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D206-642-545 CHG002 N/A										
2.0	D26001190	Extrusion Round 3" 206								
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: <table border="0"> <tr> <td>Qty</td> <td>Part Number</td> <td>Description</td> <td>Batch</td> </tr> <tr> <td>1</td> <td>D2600-1-190</td> <td>3" OD Tube</td> <td>31032</td> </tr> </table>			Qty	Part Number	Description	Batch	1	D2600-1-190	3" OD Tube	31032
Qty	Part Number	Description	Batch							
1	D2600-1-190	3" OD Tube	31032							
3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1								
Comment: LANDING GEAR RESOURCE 1 1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274 2- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 3-Drill #40 Aft cap pilot hole using DT8025 4-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274 5-Remove inner indexing ridge on fwd and aft end of skidtube as per Dwg D3274 6-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.										

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42291A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

SL 8-9-27

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ET 08-09-30

6.0

D3282041

Float Web (206L/407)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B39770 ① 8-9-30 H

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

M109338

Sikaflex expire date:

3-11-1

Start: 8-9-30

Time:

1.30

Finish: 8-10-10

Time:

8.25

(Adhere for 12 hours)

H 8-9-30

ET 08-09-30

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/01 (41)

W/O:		WORK ORDER CHANGES					
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Job Number: 42291A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position. ~~87~~ 08-10-01

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297"

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

8-10-1
M 8-10-1

10.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3285-1

Fwd Cap

B33902 ① M 8-10-1

11.0

D2649

Cross Bolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 D2649

Crossbolt spacer

B41594 ② M 8-10-1

12.0

D32751

Cross Bolt Spacer



Comment: Qty.: 37.0000 Each(s)/Unit Total: 37.0000 Each(s)

Pick:

Qty Part Number

Description Batch

37 D3275-1

Crossbolt spacer

B35210 ③ M 8-10-1

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42291A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004/Use aluminum rod.

A/R Aluminum Rod M108708/M107877 BE 08/09/25

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod M109213 BE 08/10/06

3-Grind welds flush to Fwd cap on top surface only. BE 08/09/25

4-Grind cross bolt welds flush as per Dwg D3274. SL 8-10-11

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr. 108-10-20

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

POWDER COATING

POWDER COATING



M109152



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2'-00
OF
320
2'-30

Pressure wash: FL 08/10/20

M-1 08/10/20

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-21

(X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42291A

Part Number: D206642545

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	D3415041	Nut Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3415-041	Nut Plate	1333842

21

19.0	CCR264SS33	Cherry Rivet
------	------------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivet	M101938

* JU

20.0	CR3212403	Cherry Rivet
------	-----------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CR3212-4-03	Rivet	M15984

* JU

21.0	ALS71032130	Insert
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Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Insert

Batch: M1105819

* JU

22.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 M107912

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R Sikaflex-291 M109338

Sikaflex expire date: 08/11

21 08-10-21

(XV)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 42291A

Part Number: D206642545

Job Number:



Seq. #: Machine Or Operation: Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect Nut Plate & Inserts

Handwritten: N/A
Handwritten: 5 08/10/21

24.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)
BOLT
Batch: M109297

Handwritten: JH

25.0

D353515

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B42233

Handwritten: JH

26.0

D353523

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B39134

Handwritten: JH

27.0

D353535

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B37625

Handwritten: JH

28.0

D353539

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B37277

Handwritten: JH

29.0

D353615

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B40287

Handwritten: JH

Handwritten: 08-10-21

Handwritten: KD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42291A

Part Number: D206642545

Job Number:



Seq. #:	Machine Or Operation:	Description :
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30.0	D353623	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1333965

JK

31.0	D353635	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1338905

JK

32.0	D353639	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 1333966

JK

33.0	D35371	Wearpad
------	--------	---------



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

WEARPAD

Batch: 1341082

JK

34.0	D35373	Wearpad
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARPAD

Batch: 1335697

JK

35.0	AN960C10L	washer
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Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

80 AN960C10L

Washer M109282

JK

36.0	D36721	Phenolic Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

batch 1339275

JK

08-10-21

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42291A

Part Number: D206642545

Job Number:



Seq. #:	Machine Or Operation:	Description :
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37.0	D34131	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring 1333949 *JK*

38.0	AN4C5A	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M104936 *JK*

39.0	AN960C416L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416 Washer M100993 * *JK*

40.0	D2646	Aft Cap
------	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap 1332427 * *JK*

41.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291 M109338

Sikaflex expire date: 08/11

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: M107912

JK

08.10.21

(X1)

W/O:		WORK ORDER CHANGES					
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Job Number: 42291A

Part Number: D206642545

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291

M109338

Sikaflex expire date:

08/11

INSPECT WORK TO CURRENT STEP

42.0

QC5



Comment: INSPECT WORK TO CURRENT STEP

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

B42291

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/10

Job Completion



mvf 08-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED

07.02.12 **[Signature]**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 HOP COPY ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 422911

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200

NO. 06

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 41952A
Part number: D206 642241
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base materiel: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

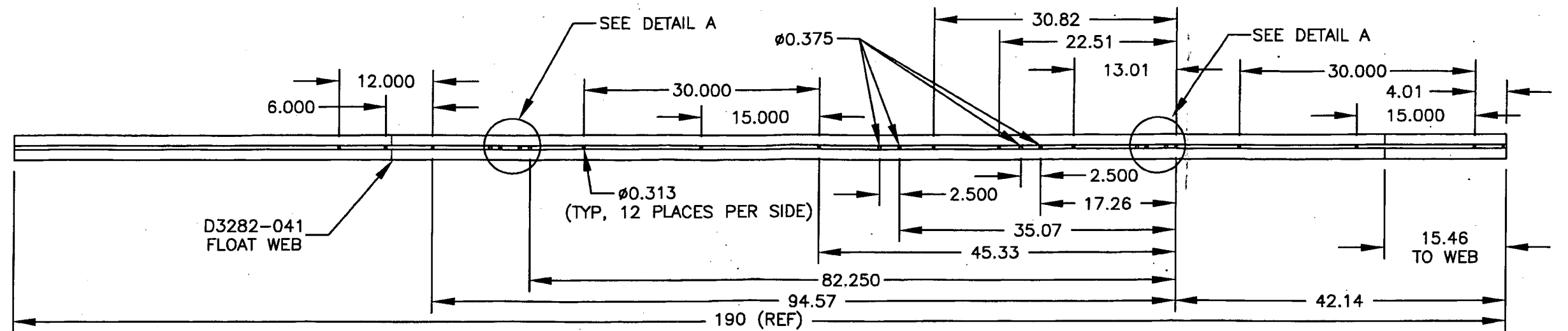
Visual:  pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

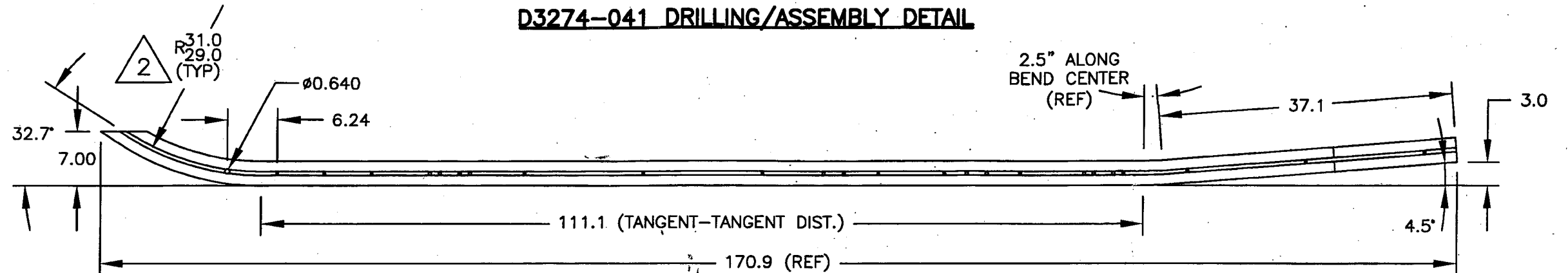
Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pet. Druval Date of Test Coupon 08-09-26
Welder Barclay Elliott Date of Test Coupon 08-09-26

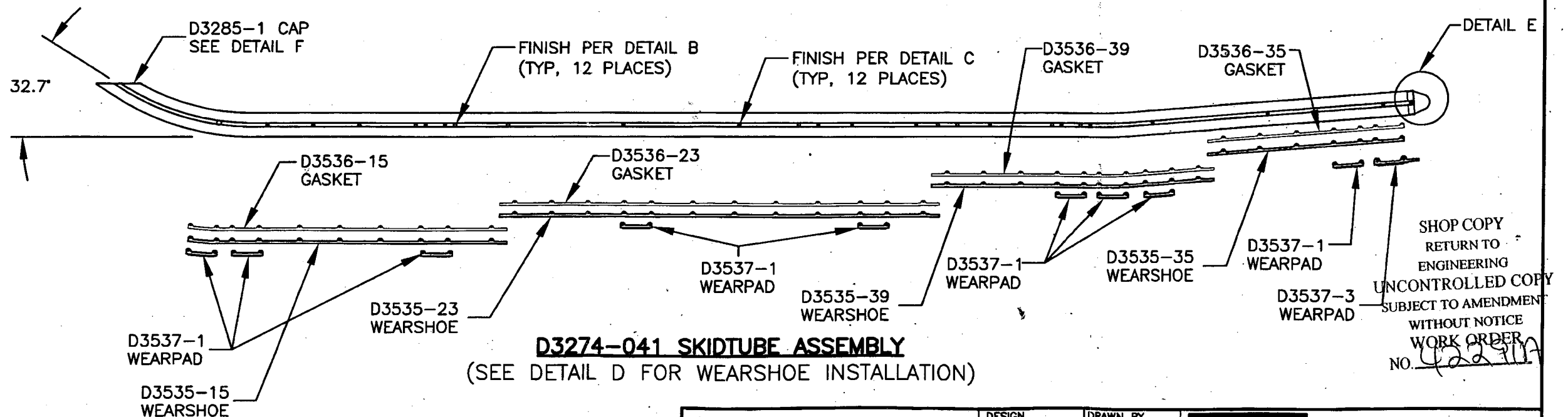
The above named individual is qualified in accordance with AWS D17.1.2001 to weld



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 2 OF 4 SCALE 1:15

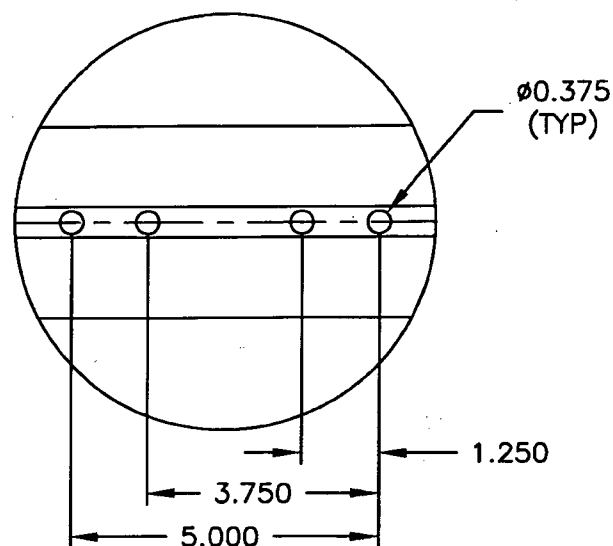


07.02.12

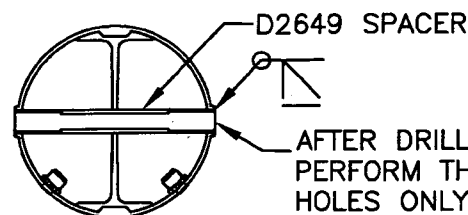
1:15 |

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DETAIL A: DRILL DETAIL

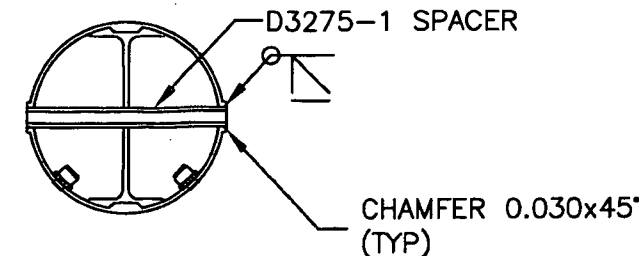


DETAIL B FOR 0.375 HOLES ONLY

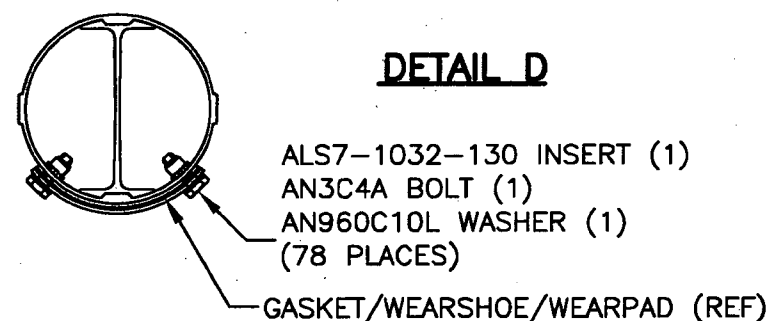


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

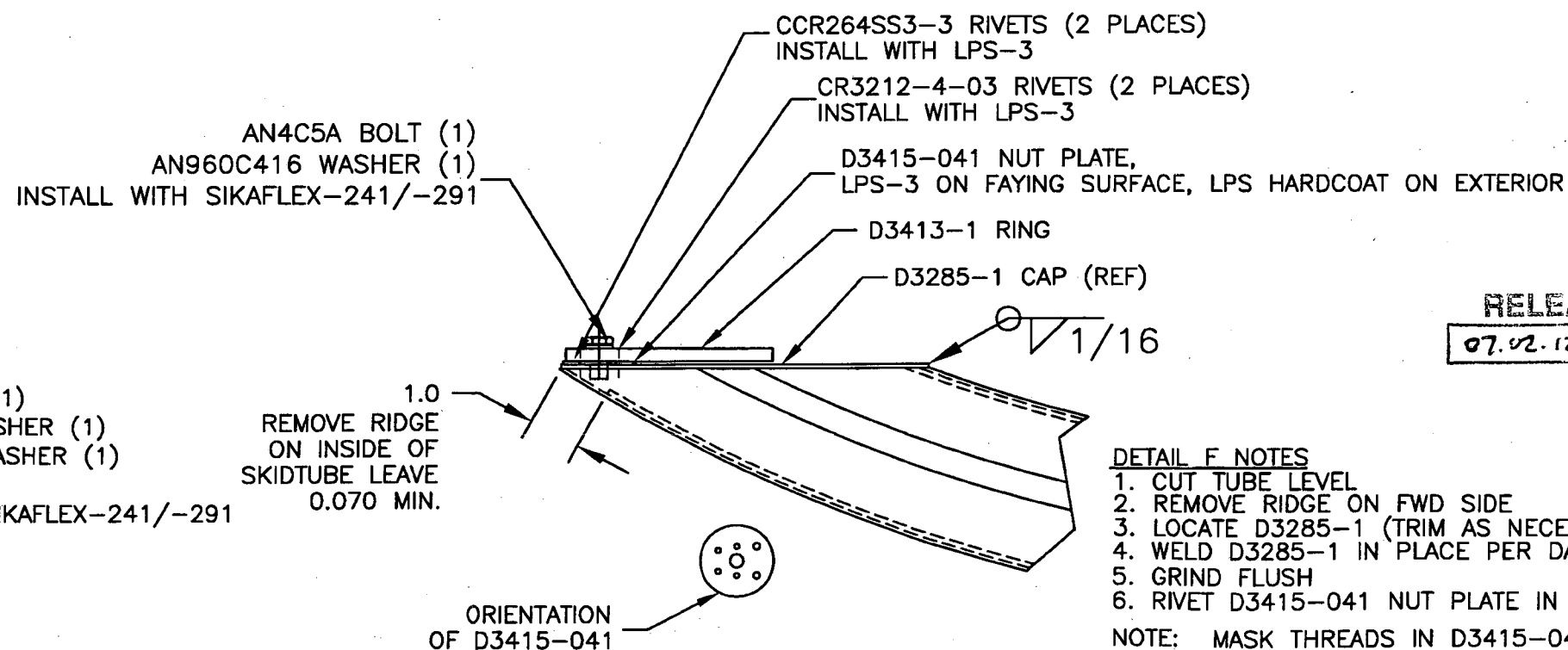
DETAIL C FOR 0.313 HOLES ONLY



DETAIL D

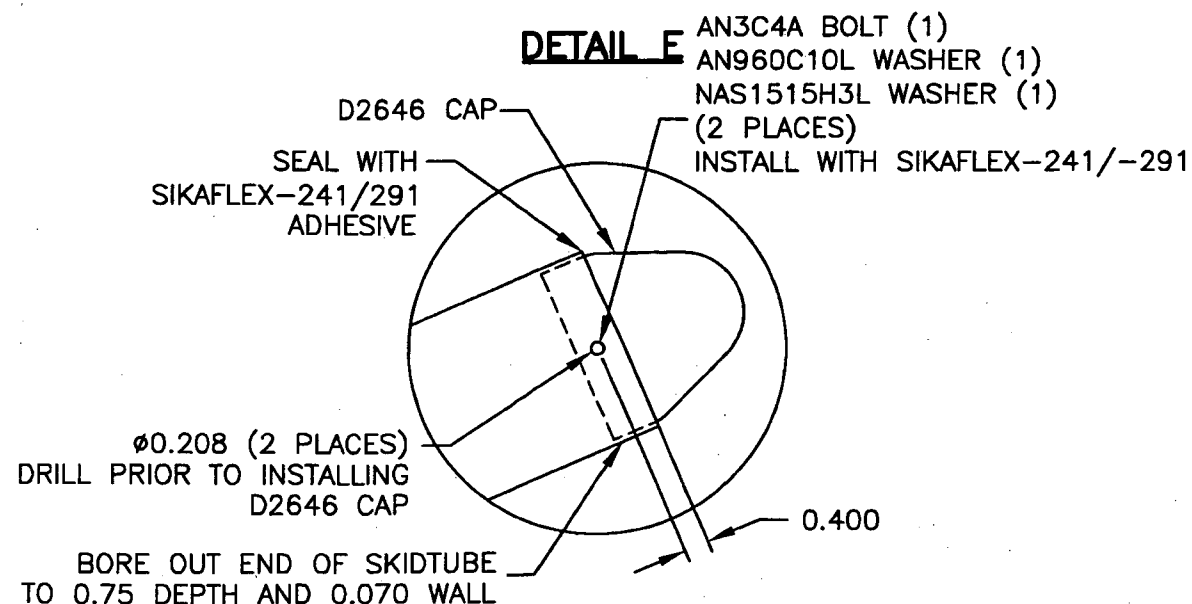


DETAIL F: END FINISHING DETAIL



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DETAIL E



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSR 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

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DESIGN

CP

DRAWN BY

PH

CHECKED

APPROVED

DATE

06.12.19

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.

D3274

TITLE

SKIDTUBE ASSEMBLY

REV. D

SHEET 4 OF 4

SCALE

1:3

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